

Work Order ID 110392-2

December-18-13 8:49:41 AM

110392

PRELIMINARY ISSUE

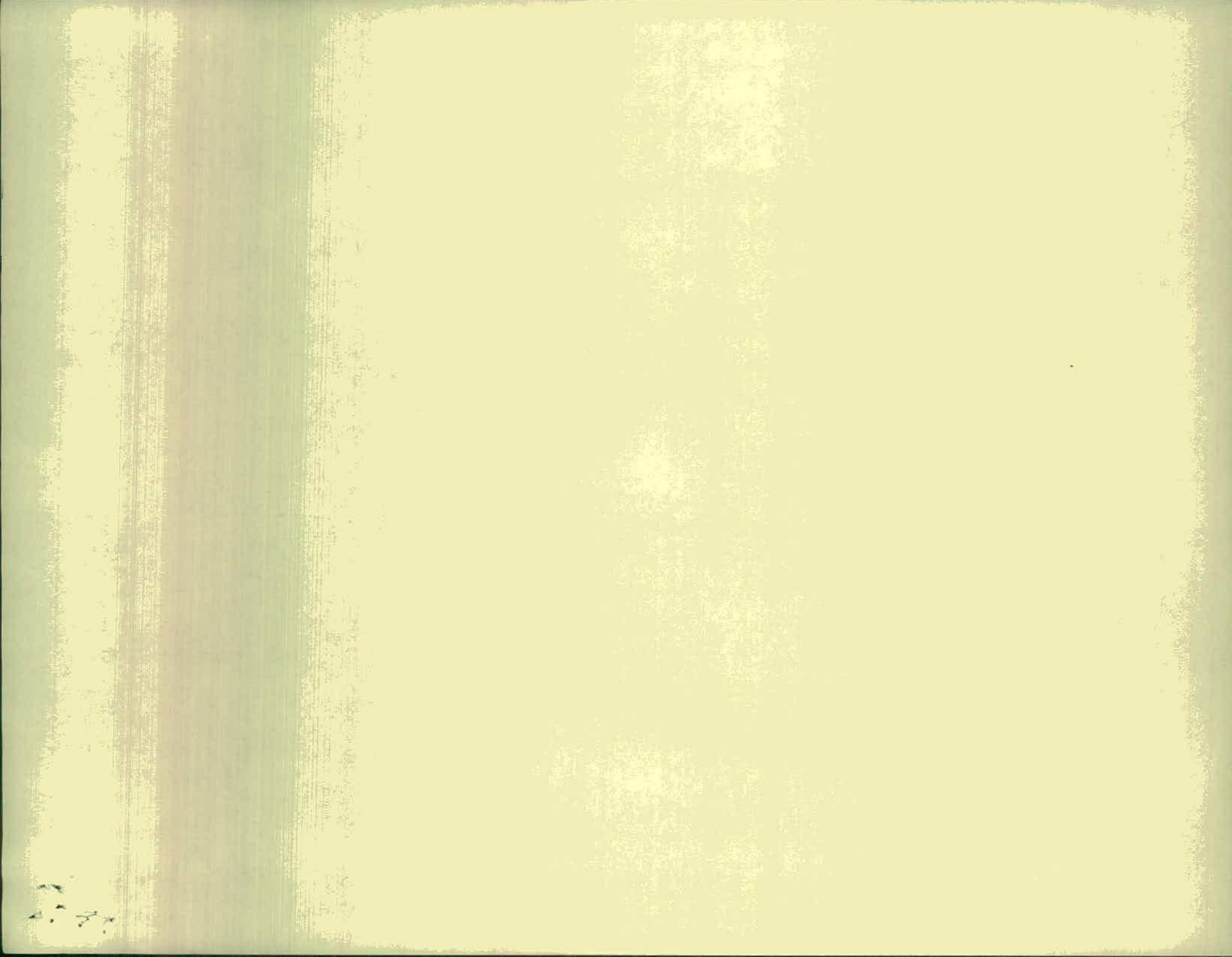
Page 1

Item ID: D4634-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Middle, Center Ceiling Panel
 Start Date: 12/18/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 12/31/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MJS Date: 13-12-18 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	e 201 PE1 Res E	0.00							
100	HAND FINISHING THERMOFORMING	0.00				x2			DL 13/12/19
100									
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00				x2			DL 13/12/19
105									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245°F
 Time IN: 7:00 pm 13/12/18
 Time OUT: 7:00 am 13/12/19



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Page 2

Item ID: D4634-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Middle, Center Ceiling Panel
 Start Date: 12/18/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 12/31/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D4634-3 and Folio FTA145 Dwg. Rev. <u>PDI</u> Folio Rev. <u>D</u> Visually inspect for proper formation and texture	0.00 0.00				<u>X2</u>			<u>DL</u> <u>13/12/19</u>
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				<u>X1</u>			<u>B</u> <u>14/01/11</u> <u>B</u> <u>13/12/22</u>
140 *140* QC Quality Control	QC2- Inspect parts off machine FA/FAIB Memo <u>N/A</u> DAS 27 9-89 <u>14/1/16</u>	0.00 0.00				<u>X1</u>			<u>B</u> <u>13/12/22</u>

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Page 3

Item ID: D4634-3 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/18/13 Start Qty: 2.00 *2*

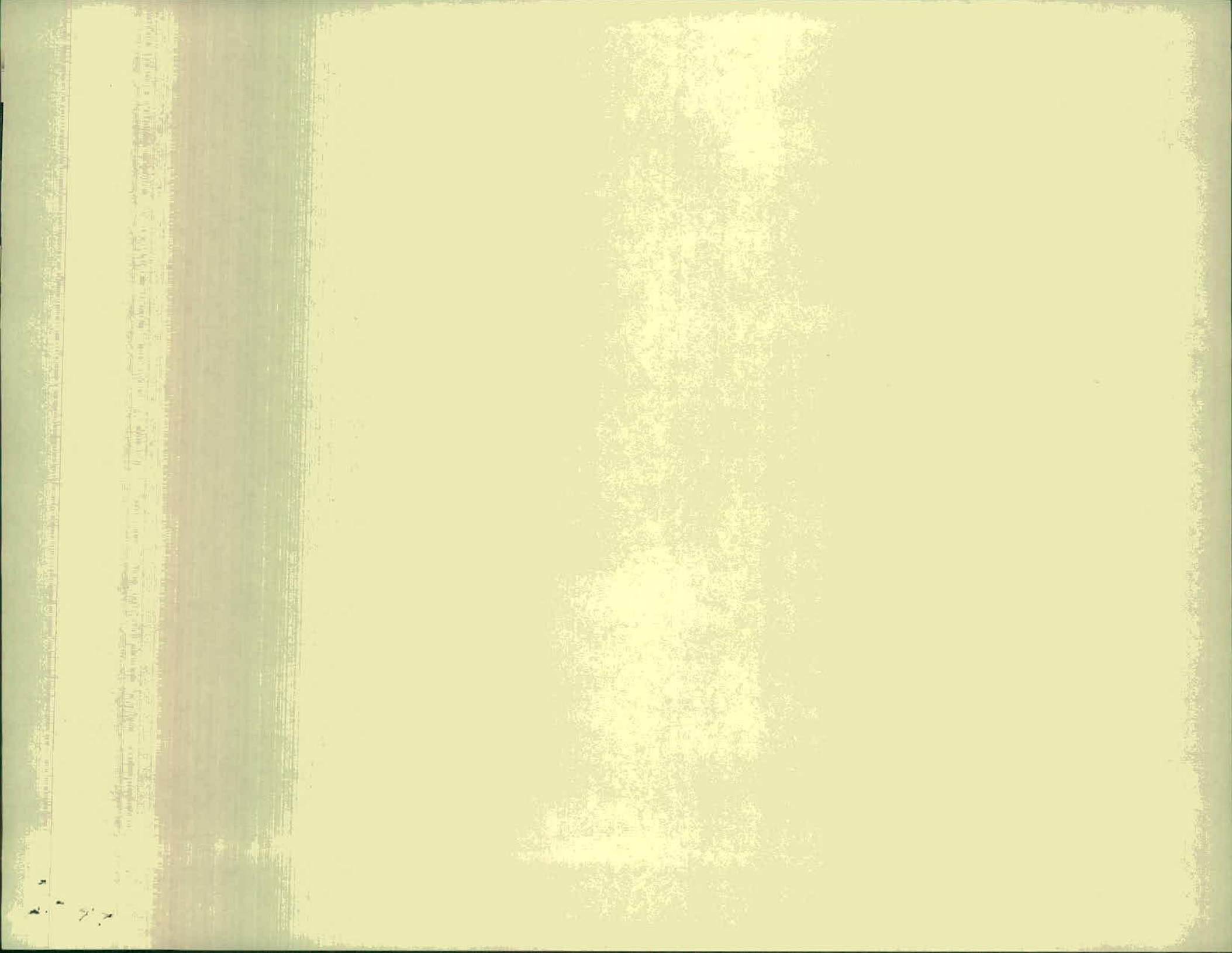
Required Date: 12/31/13 Req'd Qty: 2.00 *2*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O 6 Memo	0.00 0.00	68-6 27 DAS						Inspect as per Draw RAI PEI
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00							① SAD 17/09/17 USE IN w/o B111156
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 14-01-23 12.12.23 mf 14-01-17 POSITIVE RECALL EFFECTIVE 12.12.23 AUTH <u>u</u> RELEASED DATE <u>u</u> RD4397A POSITIVE RECALL EFFECTIVE 12.12.23 AUTH <u>u</u> RELEASED DATE <u>u</u> Release Draw Rev E44115



Picklist Print

December-18-13 8:49:47 AM

Page 1

Work Order ID: 110392

110392

Parent Item: D4634-3

D4634-3

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 12/18/13

Required Date: 12/31/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev.
B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg
Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,838.000	12.93	31			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET

**

31 ~~BB~~ 13/12/23

Location

MAT023

Loc Qty

2067.26

Loc Code

114459

229.26

123105

38

124501

1800

DART AEROSPACE LTD		Work Order: 110382
Description:		Part Number: D9634-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>W.A.</u>	Date: <u>14/01/15</u>
---------------------------------	------------------------------

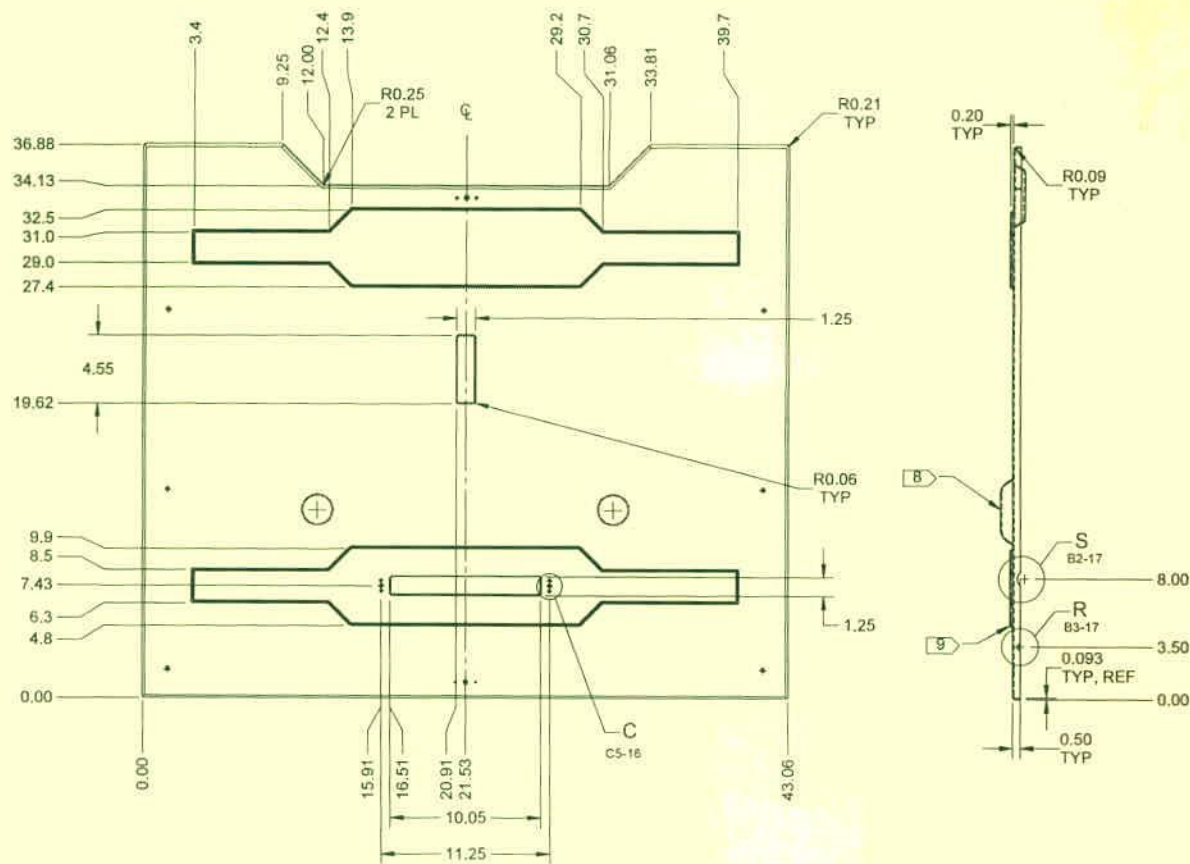
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050"	M.W.	0.056"	✓			
10.05"		10.06"	✓			
1.25"		1.23"	✓			
4.55"		4.51"	✓			
1.25"		1.23"	✓			
2.03"		2.01"	✓			
0.25"		0.25"	✓			

Measured by: <u>DAS</u>	Date: <u>14/01/15</u>
Audited by: <u>27</u> <u>9-89</u>	Date: <u>14/1/23</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.49 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4614-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

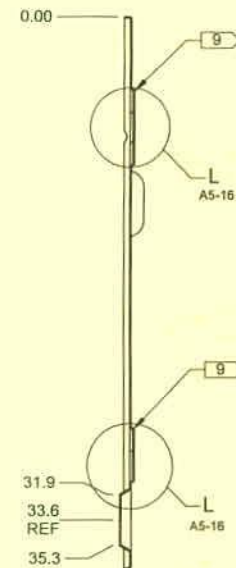
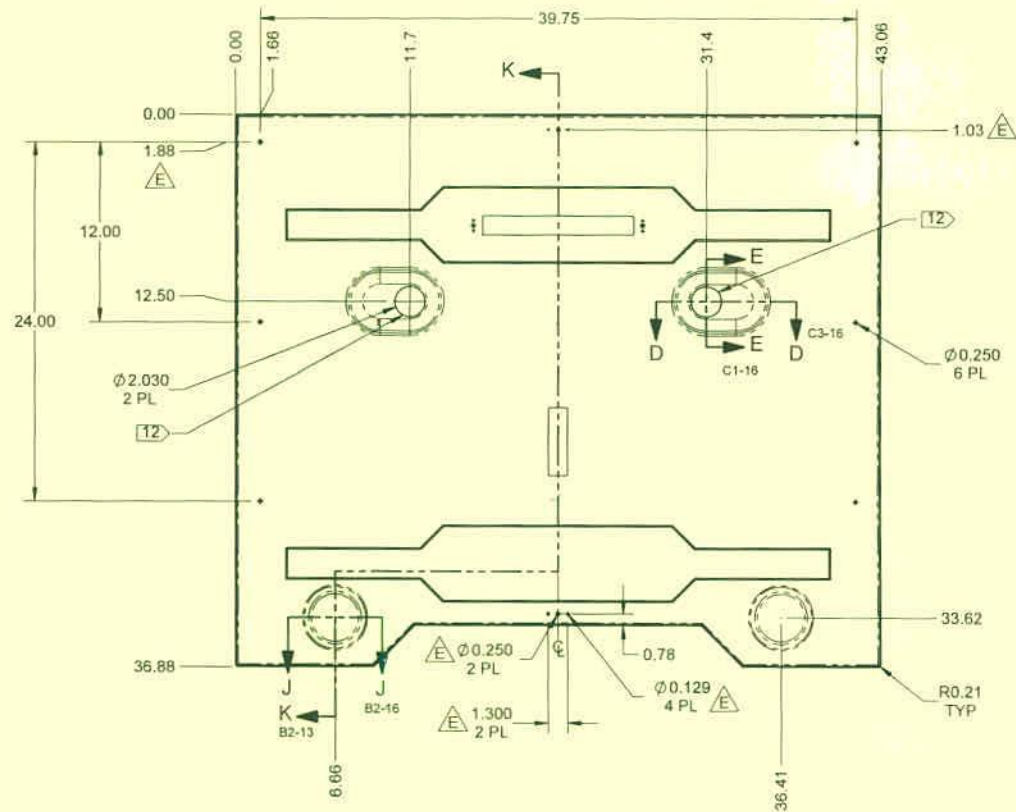
EDGES = 0.060

ELSEWHERE = 0.070

12) LOCATE $\phi 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

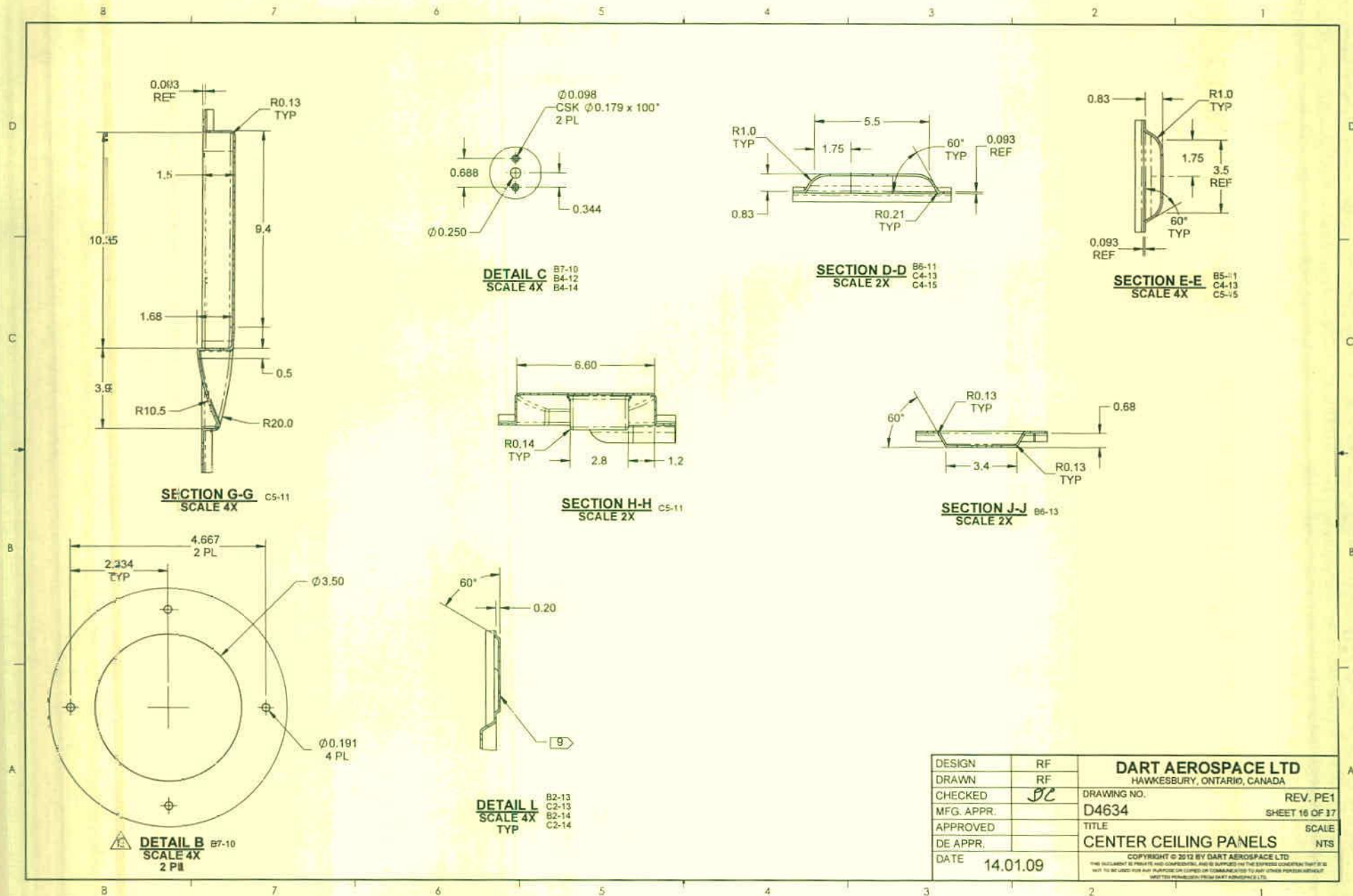
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DRAWN	RF		
CHECKED	PC	DRAWING NO. D4634	REV. PE1
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DE APPR.			
DATE	14.01.09		

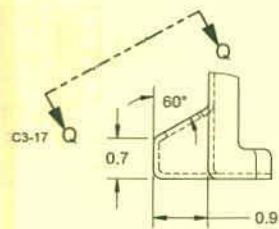


SECTION K-K B6-13

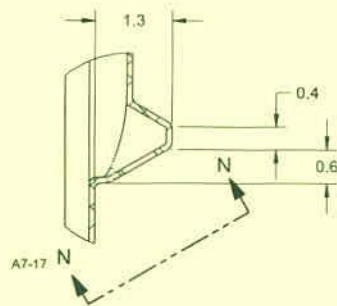
D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 13 OF 37
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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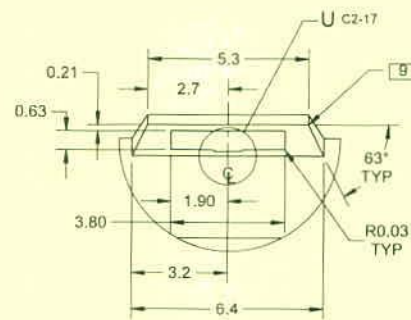




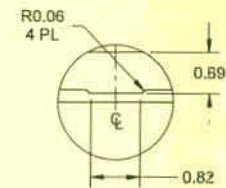
DETAIL P B3-14
SCALE 2X



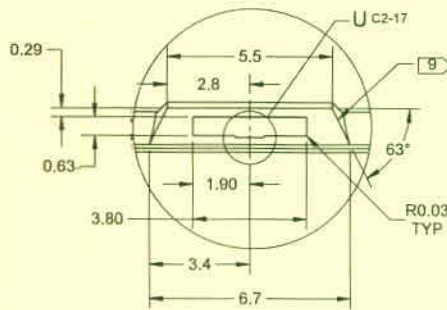
DETAIL M C3-10
SCALE 2X



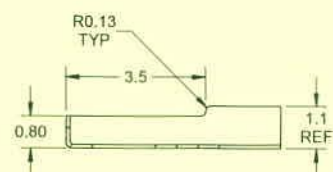
DETAIL Q B4-15
SCALE 0.5X D8-17



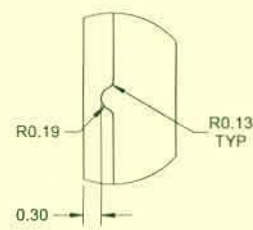
DETAIL U B7-17
SCALE 0.5X D3-17



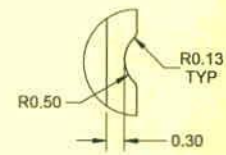
DETAIL N C5-17
SCALE 0.5X B4-15



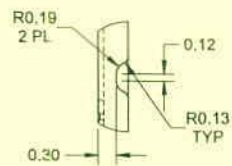
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. PE.1
MFG. APPR.		D4634	SHEET 17 OF 17
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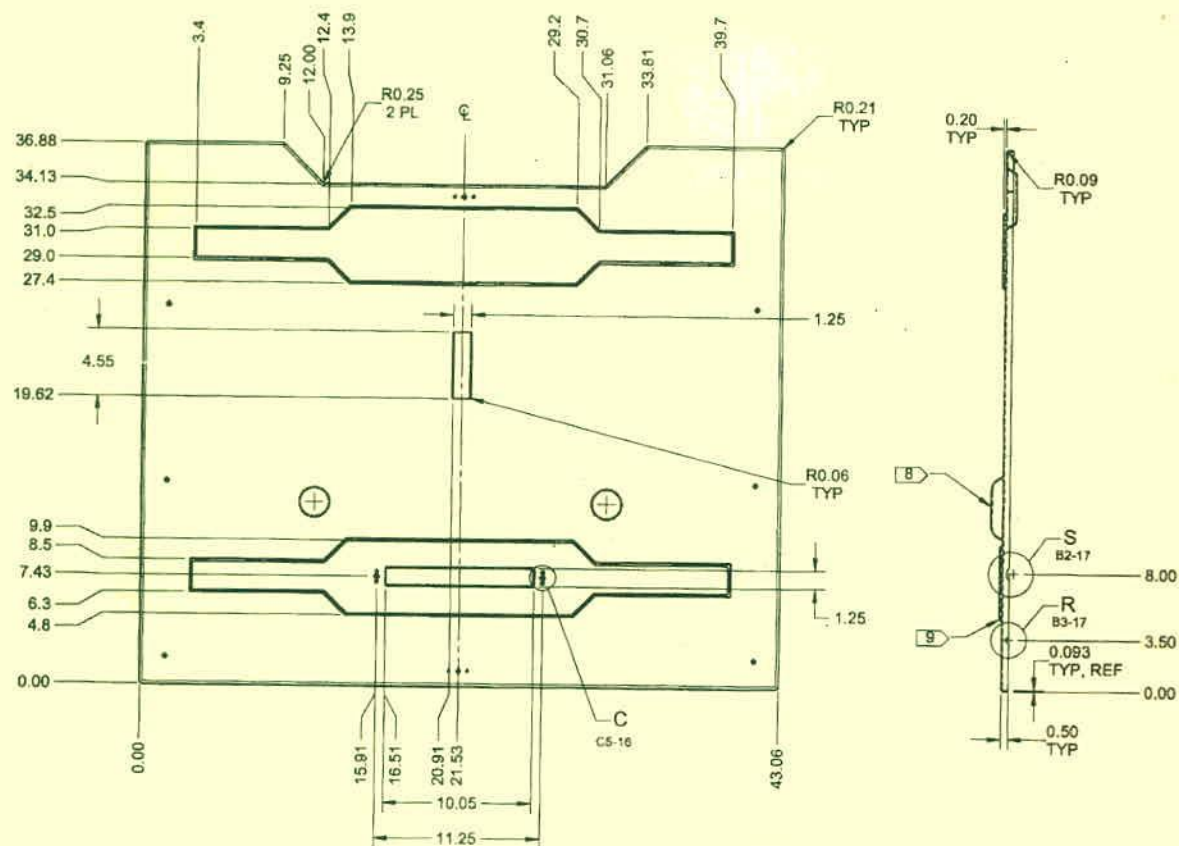


Description: <u>middle center Ceiling Panel</u>	Work Order: <u>B110392</u>
Inspection Drawing: <u>D4634</u>	Rev: <u>PEI</u> Part Number: <u>D4634-3</u>

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.8	± 0.030	4.9	✓		+	
6.3	"	6.4	✓		"	
7.43	"	7.45	✓		"	
8.5	"	8.5	✓		"	
9.9	"	9.9	✓		"	
19.62	"	19.64	✓		"	
4.55	"	4.55	✓		"	
27.4	"	27.4	✓		"	
29.0	"	29.0	✓		"	
31.0	"	31.0	✓		"	
32.5	"	32.5	✓		"	
34.13	"	34.15	✓		"	
36.88	"	36.90	✓		"	
3.4	"	3.4	✓		"	
9.25	"	9.25	✓		"	
12.00	"	12.00	✓		"	
12.4	"	12.4	✓		"	
13.9	"	14.00	✓		"	
29.2	"	29.2	✓		"	
30.7	"	30.7	✓		"	
31.06	"	31.00	✓		"	
33.81	"	33.85	✓		"	
39.7	"	39.7	✓		"	
43.06	"	43.06	✓		"	
15.91	"	15.90	✓		"	
16.51	"	16.50	✓		"	
20.91	"	20.91	✓		"	
21.53	"	21.55	✓		"	
10.05	"	10.05	✓		"	
11.25	"	11.25	✓		"	
43.06	"	43.06	✓		"	
0.50	"	0.50	✓		"	
3.50	"	3.50	✓		"	
8.00	"	8.00	✓		"	

Measured by: <u>DAS</u> <u>27</u> <u>9-89</u> Date: <u>14/1/16</u>	Checked By: Date:	QC inspector: Date:	Engineering Approval (if necessary): Date:
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NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.49 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

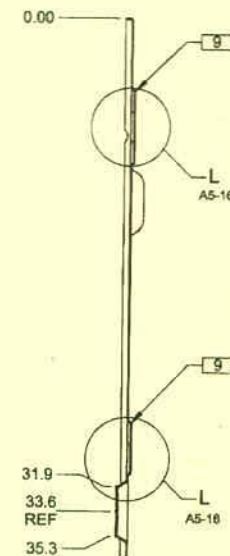
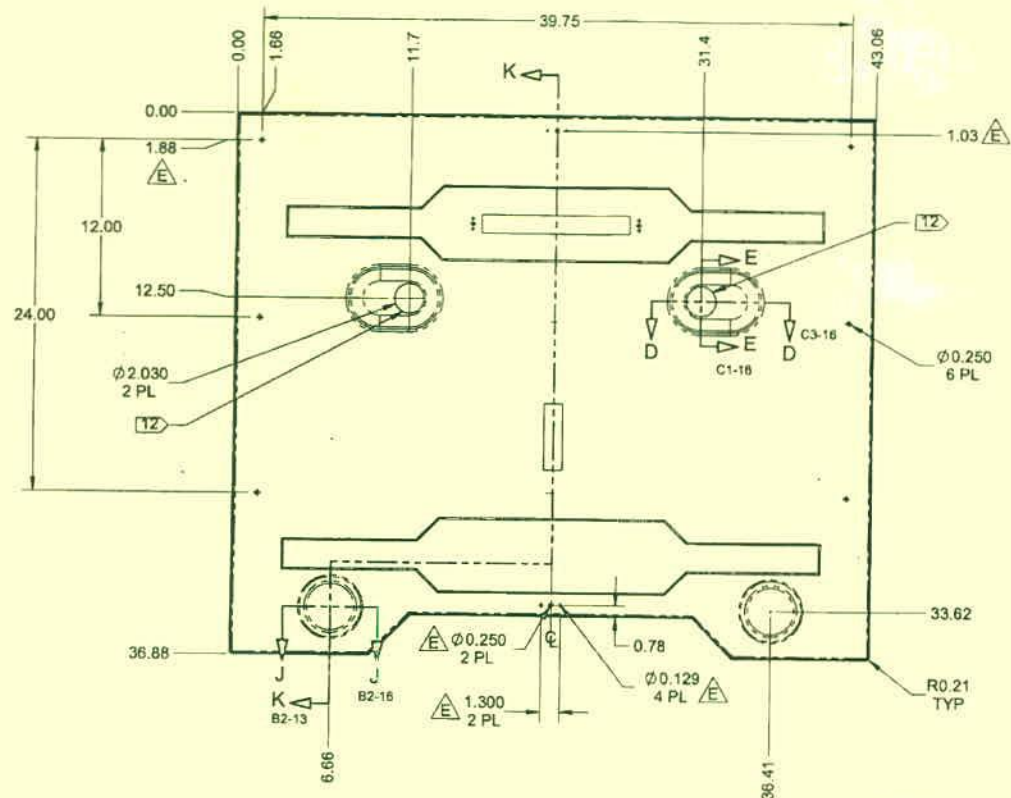
EDGES = 0.060

ELSEWHERE = 0.070

12) LOCATE $\phi 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

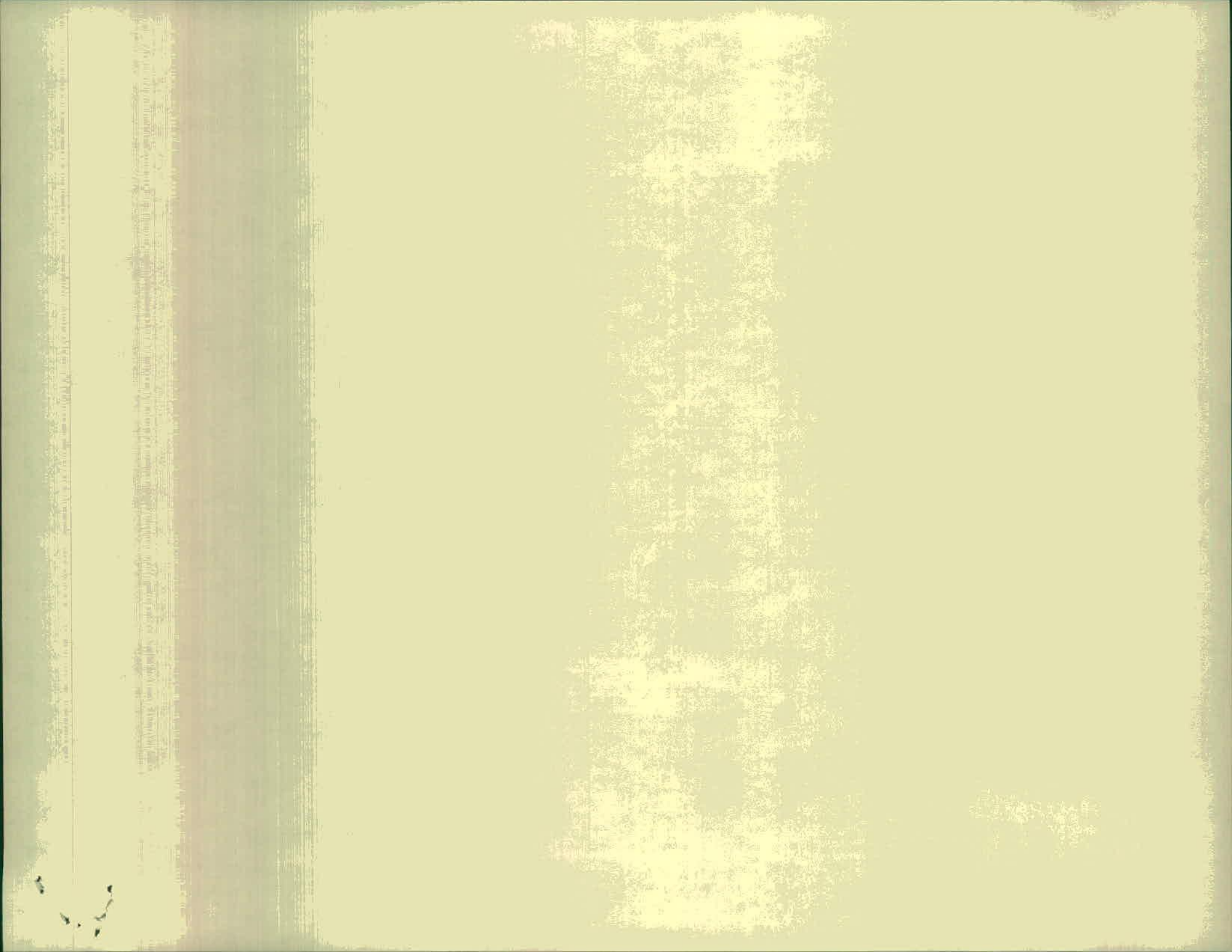
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
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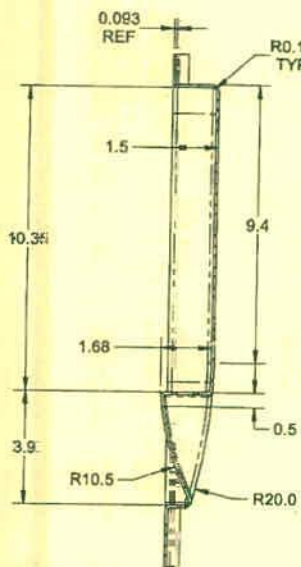


SECTION K-K B6-13

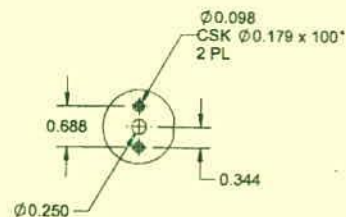
D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	AL	D4634	SHEET 13 OF 17
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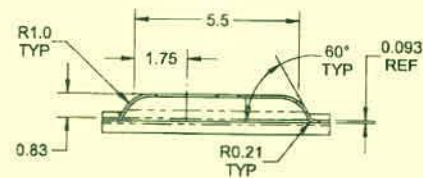




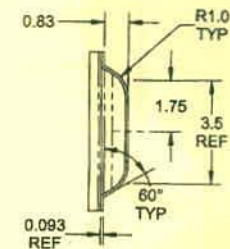
SECTION G-G
SCALE 4X C5-11



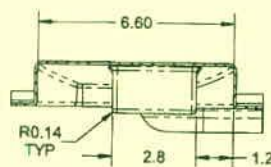
DETAIL C
SCALE 4X B7-10
B4-12
B4-14



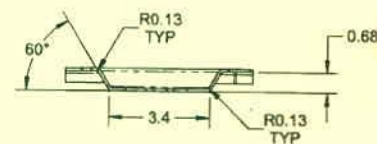
SECTION D-D
SCALE 2X B6-11
C4-13
C4-15



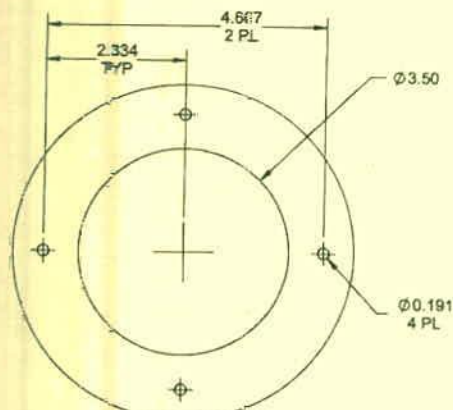
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SCALE 4X B5-11
C4-13
C5-15



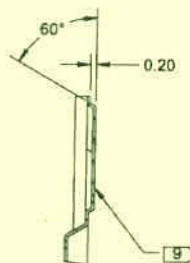
SECTION H-H
SCALE 2X C5-11



SECTION J-J
SCALE 2X B6-13

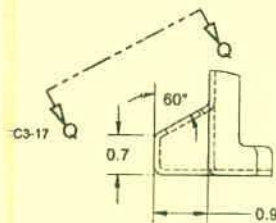


DETAIL B
SCALE 4X B7-10
2 PL

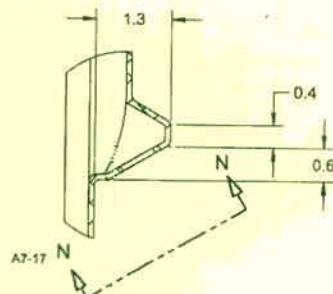


DETAIL I
SCALE 4X TYP B2-13
C2-13
B2-14
C2-14

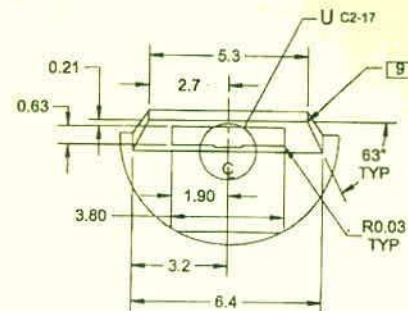
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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D4634	SHEET 16 OF 17
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CENTER CEILING PANELS	NTS
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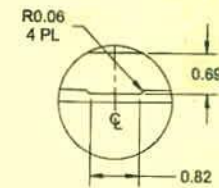
DETAIL P
SCALE 2X B3-14



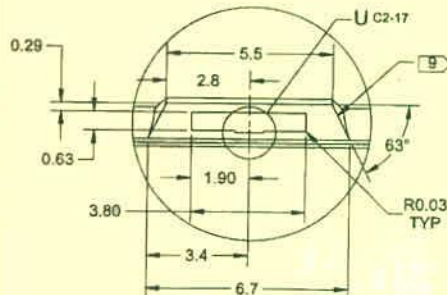
DETAIL M
SCALE 2X C3-10



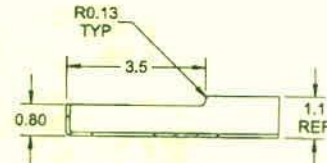
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SCALE 0.5X B4-15
D8-17



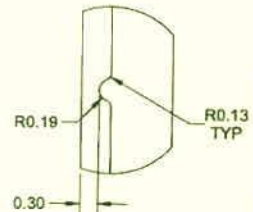
DETAIL U
SCALE 0.5X B7-17
D3-17



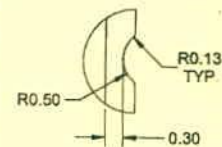
DETAIL N
SCALE 0.5X C5-17
B4-16



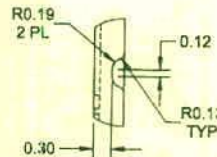
SECTION O-O
SCALE 1.3X B6-14



DETAIL R
SCALE 4X B3-10
C3-10
B2-12



DETAIL S
SCALE 4X B3-10
C2-12



DETAIL T
SCALE 4X C2-14

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